slip Oct.30

Work Ordenseptember-24-1		49		Page 1							
Item ID: Revision ID: Item Name:	D350-591-311 Heli-Access-Ste			Accept	*N900	<b>040</b>	100	<b>)*</b> s	etup Sta	iVi	S1* S2*
Start Date: Required Date: Reference:		Start Qty: 5.00 Req'd Qty: 5.00	*5* *5*		Cust Item I Customer:	D:				, u	
Approvals:	Process Plan:	: MLJ	Date: 12 - 09 - 2			ate:		R	Run Star Sto	" <b> </b> \	R1* R2*
Sequence ID/ Work Center II		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revis	ion Nbr									
D3272	Rev B	3							4		
*1 \\ \\ DC \\ \ \ \ \ \ \ \ \ \ \ \ \ \ \		DOCUMENT CONTRO  Memo  Photocopy b		0.00 9-69 V	(1) (1) CHG001			1	1401	MLTI	(2-10-23
110	ī	Large Fab		0.00				_			N
*110* Large Fab	1			0.00					P_		M.
Large Fab		Memo 1-Bevel end	for welding FWD ONLY						ι		12.10.11
		2-Weld Supp	oort using Jig DT8719, w um Rod <u>M/<b>1</b>2</u> 358 M/22437	eld Fwd End Plate as per (	QSI 004 & Dwg						12.10.11 Le 12.10.16

											DQA:	Date:	·
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORN	/IANCE / UPD				
											QA Closed:	Date:	· ·
Work Ord	or.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	,
WOIK OIG	C1.					Rework	1		Skid-tube	Crosstube		Water Jet	Engineering
Part I	No.					Scrap	1	8	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	•					Use-as-is	1	1	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR I	No.	<del></del>				Work Order Update	]		Large Fab	Composite		Supplier	
Root					Descri	ption of work order update		Initial	Acti	ion	Sign &		
Cause		Date	Step	Qty	(	or Non-conformance	Cr	nief Eng	Descri	iption	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling	Ш												
Operator	Ш												
Material	Ш												
Setup	Ш												
Other	Ш		ļ										
Process	Ш												
Supplier	Ш												
Training	Ш												
Unapproved				<u> </u>				ä					<u> </u>
						<u> </u>	AUI	LT CATE	GORY				
Landi		1				General	_	7			<b>-</b>		_
	Ш	Bending				Bend	L	Grain.			Ovalized	_	Pressure/Forced
		Centre No	ot Concei	ntric to	o/s	BOM/Route	L	Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged	L	Inspecti	on Incomplete		Part Incorre	ct	Weld
	-	Crushed/	Crimped.			Burrs		-{	ions Incomplete/U	Inclear	Part Lost/M	issing	Wrong Stock Pulled
	Ш	Cuffs				Contamination		Mainte	nance		Part Moved		
	Ш	Heat Trea	at			Countersink		Mislabe	led		Positioned \	Wrong	
	Ш	Inspectio	n Strip in	Tube		Cut Too Short	Misread Power Loss/Surge Other				Other		
	1	Ripples in	Bend			Drill Holes		Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde September-24-12			*90749*									Page 2
Item ID: Revision ID: Item Name:	D350-591-	311 -Step, Long LH		Accept	*N900	<u>040</u>	100	)*	Setup	Start Stop	*N:	S1*
	9/24/12	Start Qty: 5.00 Req'd Qty: 5.00	*5* *5*		Cust Item I Customer:	D:					IVI	<b>7</b> /*
Approvals:		lan:	Date:			ate:			Run	Start Stop	*NF	₹1* ₹2*
Sequence ID/ Work Center II 120 *120 *QC Quality Control	)	Operation Description QC9- Inspect visual per Memo	QSI004- Fusion Welds	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Rej Qty	/ I	Reject Number 12-10-/	Insp. Stamp
130 *130* QC Quality Control		QC5- Inspect part compl	eteness to step on W/O	0.00 <b>AS</b> /	nliolis		(	et et				
140 *140* HandFinish		Chemical Conversion Co	oat per QSI005 4.1	0.00				5		Nh.	1210,	16'

Memo

Hand Finishing

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-O	100	NFORM	MANCE / UPDA	TE	·		
											QA Closed:	Date:	•
Work Ord	or.			·		DISPOSITION				AGAINST DE	PARTMENT	PROCESS	¢
Part						Rework Scrap			Machining	Crosstube Small Fab		Water Jet d. Eng. Coor.	Engineering Quality
NCR	No.				<del></del>	Use-as-is Work Order Update		•	~ <u>~</u>	Finishing omposite	Rec/Stor	e/Packaging Supplier	Other
Root					Descri	ption of work order update		Initial	Action		Sign &		
Cause		Date	Step	Qty	(	or Non-conformance	Cr	nief Eng	Descripti	ion	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator									:		,		
Material													
Setup													
Other													
Process													
Supplier													
Training			}										
Unapproved													
						F	AUI	LT CATE	GORY				
Landi	ng (	Gear				General		di •				<del></del>	<b>-</b>
		Bending				Bend	L	Grain			Ovalized		Pressure/Forced
	L	Centre No	ot Concer	ntric to	o/s	BOM/Route	L	Hardwa	re		Over/Under	tolerance	Temperature/Cure
,	Ŀ	Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
		Crushed/	Crimped,			Burrs		Instruct	ions Incomplete/Uncl	ear	Part Lost/Mi	ssing	Wrong Stock Pulled
Cuffs Contamination				Maintenance				Part Moved		<del></del>			
		Heat Trea	ıt			Countersink	Mislabeled			Positioned V	Vrong		
	Inspection Strip in Tube Cut Too Short				Cut Too Short	Misread			Power Loss/	Surge	Other		

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ord September-24-				*907	749*							Page 3
Item ID: Revision ID: Item Name:	D350-591-	311 -Step, Long LH		Accept	*N900	040	100	)*	Setup	Start Stop	*N	S1*
Start Date: Required Date Reference:	9/24/12 :: 10/26/12	Start Qty: 5.00 Req'd Qty: 5.00	*5* *5*		Cust Item l Customer:	ID:					IV	. 7/
Approvals:	Process P	lan:	Date:	Tooling:	D	ate:			Run	Start	*N	R1*
	QC:		Date:	SPC (Y/N):	D	ate:				Stop	*N	R2*
Sequence ID/ Work Center	I <b>D</b>	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Re Qt		Reject Number	Insp. Stamp
*150 *150*		QC3- Inspect Part Finish		0.00				5		ek)		M.
QC Quality Control		Memo		0.00						φ		12.10.17
180		Large Fab		0.00						/		
*180* Large Fab		-		0.00				_5		Ø		Re
Large Fab		Memo 1-Assemble	Leg Assembly as per Do							'		12.10.1
		2-Leave one	rivet out until welding i	s complete.								12.10.1
		3-Bevel Aft	end for welding									
		4-Inspect for	foreign object as per Q	SI 024								

5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/RAluminum Rod 122358

6-Grind End Plate flush

7-Install last rivet as per Dwg.

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-CONFORMANCE / UPDATE  DISPOSITION  Rework Scrap Use-as-is Work Order Update Large Fab Composite Supplier  Thermoforming Finishing Small Fab Prod. Eng. Coor. Supplier  Large Fab Composite Sign & Verification QC I  Thom of work order update Chief Eng Description Date Verification QC I  Bend Grain Ovalized Over/Under tolerance Broken/Damaged Inspection Incomplete Broken/Damaged Instructions Incomplete Unclear Part Lost/Missing Wrong Scontamination Maintenance Part Moved  Part Moved  AGAINST DEPARTMENT/PROCESS  Water Jet Description Ovalized Over/Packaging Supplier  Prod. Engine Prod. Engine Ovalized Over/Inder tolerance Temperature Over/Under tolerance Part Incorrect Weld Wrong Scontamination Maintenance Part Moved							
											QA Closed:	Date:	
Work Ord	er.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	r
, work ord	٠	<del></del>			<del></del>	Rework	]		Skid-tube	Crosstube	]	Water Jet	Engineering
Part I	No.					<b>!</b> —	1		<b>  </b>	<b></b>	Pro		Quality
	•					Use-as-is	1	•		Finishing	Rec/Sto	re/Packaging	Other
NCR I	No.					Work Order Update	]		Large Fab	Composite		Supplier	
,							·····	<u> </u>					
Root				,		·	1				1		
Cause		Date	Step	Qty	(	or Non-conformance	Ch	nief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data													į
Equip/Tooling	Ш		·										
Operator							İ						
Material	Ш												
Setup	Ш												
Other									!				
Process	Ш												
Supplier													
Training						•							
Unapproved													
						·	AUI	T CATE	GORY				
Landi	ر ت					7	_	7			٦	F	7
<u> </u>	Ш	Bending				Bend	L	Grain			-		Pressure/Forced
	Ш	Centre No	ot Concer	ntric to	o/s	4		Hardwa	re		4 ′	<b>⊢</b>	Temperature/Cure
	-	Cracks				Broken/Damaged	L	Inspecti	on Incomplete		Part Incorre	ct	Weld
	-	Crushed/	Crimped.			Burrs		-1	•	Unclear		issing	Wrong Stock Pulled
	Ш	Cuffs				Contamination	L	Mainte	nance		Part Moved		
	Ш	Heat Trea	t			Countersink		Mislabe	eled	L	Positioned V	Vrong	-
	1 1	Inspection	1 Strip in	Tube	1	Cut Too Short	1	Misread	1		Power Loss/	Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

**Work Order ID 90749** *September-24-12* 2:55:13 PM

## \*90749\*

Page 4

Item ID: Revision ID:	D350-591-	311		Accept	*N900	<u>0401</u>	იი	* 9	Setup Sta	I VI	S1*	
Item Name:	Heli-Access	-Step, Long LH							Sto	p *N	S2*	
Start Date: Required Date:	9/24/12 10/26/12	Start Qty: 5.00 Req'd Qty: 5.00	*5* *5*		Cust Item I Customer:	D:						
Reference:									- a.			
Approvals:	Process P	lan:	Date:	Tooling:	Da	ate:		F	Run Sta	1/1	R1*	
	QC:		Date:	SPC (Y/N):	Da	ate:			Sto	*N	R2*	
Sequence ID/ Work Center II	)	Operation Description		Set Up/ Run Hours	Tool ID			Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
190		QC10- Inspect visual per	r QSI004- ground welds	0.00				_	-		-	
*190*		Memo		0.00	12.10.1	7	-	5 <sub>x</sub>				
Quality Control												
200		QC5- Inspect part compl	eteness to step on W/O	0.00 SmB	10 - 10 -	-17		_				
*200*					12 10		,	$\supset$	. •		, en 2 j.	
QC Quality Control		Memo		0.00								_
210		Chemical Conversion Co	oat per QSI005 4.1	0.00				_	_	4	a –	
*210* HandFinish				0.00			_	5	2	G 12-18	1) 1 <del>/</del>	_
Hand Finishing		Memo		0.00								

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-O	100	NFORM	ANCE / UP	DATE			
											QA Closed:	Date:	
Work Ord	۵r·					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	ŕ
Work ord	C1.					Rework	1		Skid-tube	Crosstube	]	Water Jet	Engineering
Part I	No.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is	1	Therm	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR	No.					Work Order Update	]		Large Fab	Composite	]	Supplier	
		·	-r	r		<u> </u>					T	T	<del></del>
Root		_				ption of work order update	1	nitial		tion	Sign &		
Cause	,	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling	L				:								
Operator	Ш												
Material													
Setup								, j4					
Other								-ar					
Process													
Supplier													
Training													
Unapproved													
						F	AUL	T CATE	GORY				
Landi	ing (	Gear				General		_			_		_
		Bending				Bend		Grain			Ovalized		Pressure/Forced
		Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ect	Weld
		Crushed,	Crimped			Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/M	lissing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte			Part Moved	_	_
		Heat Tre	at			Countersink		Mislabe	led		Positioned	Wrong	
		Inspection Strip in Tube Cut Too Short				Cut Too Short	<b>├</b> ─-{			Power Loss,	/Surge	Other	

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde September-24-12	er ID 90749 2 2:55:13 PM		*907		Page 5	
Item ID: Revision ID: Item Name:	D350-591-311 Heli-Access-Step, Long	IU	Accept	*N900040100	<b>)*</b> Setup Start	*NS1*
	9/24/12 Start (	2ty: 5.00 *5 Qty: 5.00 *5		Cust Item ID: Customer:		*NS2*
Approvals:	Process Plan:		9 -	Date:	Run Start Stop	*NR1* *NR2*
Sequence ID/ Work Center II 220 *>>> \(^*\) Powdercoat Powder Coating	White Glo		30 0.00 =	Tool ID Tool # Plan Code		Reject Insp. Number Stamp    12/10/
230 *230* HandFinish Hand Finishing	Wing Wa	lk as per dwg QSI005 4.4 Batch	0.00		56_	BL 121019
240 *240*	QC3- Insp	pect Part Finish	0.00		5 in 41 J	Ill a lo l
* <b>740</b> * QC Quality Control		Memo	0.00		<u> </u>	<u> </u>

												DQA:	Date:	
NCR:	Yes	/ No					WORK ORDER NON-O	100	NFORI	MANCE / UPD		QA Closed:	Date:	
						_						QA Closed.	Date.	· · · · · · · · · · · · · · · · · · ·
Nork Ord	er.						DISPOSITION				AGAINST DE	PARTMENT	PROCESS .	′ 1
WOIN OIG	٠,٠,						Rework	1		Skid-tube	Crosstube		Water Jet	Engineering
Part i	No.						Scrap	1	ŀ	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
			٠				Use-as-is		Thern	noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR	No.						Work Order Update	]		Large Fab	Composite		Supplier	
				<u> </u>	D		otion of work order update		nitial	Actio		Sign &		[
Root Cause		Date	Step	Qty	Desi		or Non-conformance	1	illida ief Eng	Descrip		Date	Verification	QC Inspector
oc/Data	Г	Date	Step	aty			Non comormance	1	ilet Eng	Descrip	<u> </u>	Date	Vermedation	Qe mspector
quip/Tooling														
perator		•												
Iaterial														
etup														
ther														
rocess			-											
upplier														
raining														
Inapproved														
							F	AUL	T CATE	GORY			·	
Landi	ng (	Gear			_		General		-			-	<del></del>	-
	L	Bending					Bend		Grain			Ovalized		Pressure/Forced
	L	Centre No	ot Concer	ntric to	o/s		BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	<u> </u>	Cracks					Broken/Damaged		4 '	on Incomplete		Part Incorre	<b></b>	Weld
		Crushed/0	Crimped.				Burrs	L	Instruct	ions Incomplete/Ur	nclear	Part Lost/Mi	issing	Wrong Stock Pulled
		Cuffs			- [		Contamination		Mainte	nance	<u> </u>	Part Moved		
	L	Heat Trea					Countersink		Mislabe			Positioned V		7
	<u></u>	Inspection		Tube			Cut Too Short	$\perp$	Misread	I		Power Loss/	Surge	Other
	L	Ripples in					Drill Holes		Offset					
		Torque W			n		Drawing		Out of	Calibration				!
		Turning S	equence				Finish	1	Out of 9	Sequence				

Outside Dimensions

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde September-24-1.			*	90749*
Item ID: Revision ID: Item Name:	D350-591-3	Step, Long LH	Accept	*N900040100*
	9/24/12	Start Qty: 5.00 Req'd Qty: 5.00	*5* *5*	Cust Item ID: Customer:

Date:

Date:

Tooling:

0.00

0.00

**SPC (Y/N):** 

Set Up/

Run Hours

Tool ID

Process Plan:

Operation

Description

Memo

Pick Kit

QC: \_\_

Approvals:

Sequence ID/

\*250\* Packaging

Packaging

250

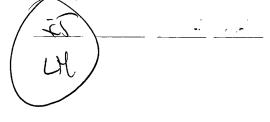
Work Center ID

Da Da			R	kun Sta Sto	_ "I\ <u>\</u>	R1* R2*	
)	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	,

Setup Start

Page 6

•				
260	QC4-100% Inspect kits f	or completeness	0.00	(iii)
*260* QC Quality Control	Memo		0.00	16 / (1/2)
<sup>270</sup> * <b>27</b> 0*	Packaging		0.00	
Packaging Packaging	<b>Memo</b> Identify and p	pack for shipping as per PPI	0.00 PD350-591-3	311
	Location Location			





									DQA:	Date: _	
NCR: Yes	s / No				WORK ORDER NON-C	ONFOR	MANCE / UP		QA Closed:	Date:	. •
Work Order:		•			DISPOSITION			AGAINST DEF	PARTMENT	/PROCESS	<b>.</b>
Part No					Rework Scrap Use-as-is Work Order Update		Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Initial	Ac	ction	Sign &		
Cause	Date	Step	Qty	(	or Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling	]										
Operator										er ng	
Material	_]										
Setup							}				
Other							Ì	ŕ	·		
Process											
Supplier											
Training						]					
Unapproved											
					F	AULT CATE	GORY				

ndin	g Gear	 General		_		_	 _
	Bending	Bend		Grain		Ovalized	Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route		Hardware		Over/Under tolerance	Temperature/Cure
	Cracks	Broken/Damaged		Inspection Incomplete	L	Part Incorrect	Weld
	Crushed/Crimped_	Burrs		Instructions Incomplete/Unclear		Part Lost/Missing	Wrong Stock Pulled
	Cuffs	Contamination		Maintenance		Part Moved	
	Heat Treat	Countersink	L	Mislabeled		Positioned Wrong	 _
	Inspection Strip in Tube	Cut Too Short		Misread		Power Loss/Surge	Other
	Ripples in Bend	Drill Holes		Offset			
	Torque Waves in Extrusion	Drawing		Out of Calibration	٠		
	Turning Sequence	Finish		Out of Sequence			
	Wave/Twist in Tube	Folio		Outside Dimensions			

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ord				*907	749*							Page 7
Item ID: Revision ID: Item Name:	D350-591-	-Step, Long LH		Accept	*N900	<b>040</b>	100	)*	Setup	Start Stop		S1* S2*
Start Date: Required Date: 'Reference:	9/24/12	Start Qty: 5.00 Req'd Qty: 5.00	*5* *5*		Cust Item I Customer:	D:					I V	.J/
Approvals:	Process P	lan:	Date:	Tooling: SPC (Y/N):		ate:			Run	Start Stop	1/7	R1* R2*
Sequence ID/ Work Center II	)	Operation Description QC21- Final Inspection	Work Order Release	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Re Qty	•	Reject Number	Insp. Stamp
*280*		Memo		0.00						2/0	0/2	4

Memo

Quality Control

\$ 12 10-2M

											DQA:	Date:	4
NCR:	Yes	/ No				<b>WORK ORDER NON-</b>	COI	NFORM	ANCE / UPD	DATE	•		
											QA Closed:	Date	
Work Ord	or.					, DISPOSITION				AGAINST DE	PARTMENT	PROCESS	•
Part f	No.					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	ŧ	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					i	ption of work order update	1	Initial	Acti	ion	Sign &		
Cause	,	Date	Step	Qty	(	or Non-conformance	Ch	nief Eng	Descri	iption	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved								T CATE	CORV				
1		<u> </u>				General F	AUI	LT CATE	JURY			<del> </del>	· · · · · · · · · · · · · · · · · · ·
Landi		Bending Centre No Cracks Crushed/ Cuffs		ntric to	o/s	Bend BOM/Route Broken/Damaged Burrs Contamination		- '	on Incomplete ions Incomplete/U	Inclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved	ct	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
	$\vdash$	Heat Trea	ıt			Countersink		Mislabe			Positioned \	Vrong	_
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	l		Power Loss/	Surge	Other
		Ripples in	Bend			Drill Holes		Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

September-24-12 2:55:12 PM

Work Order ID:

90749

Parent Item:

D350-591-311

Parent Item Name:

Heli-Access-Step, Long LH

**Start Date:** 9/24/12

Required Date: 10/26/12

Start Qty: 5.00

Required Qty: 5.00

**Comments:** 

IPP Rev:A04.03.22New issue KJ/RF

IPP Rev:B 07-06-09 Added D3272-1 JLM

IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verifed by:EC

IPP Rev:D fixe

	route seq in bom D	DD 10.04.28 verific	ed by:EC	2	- +								
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3272-1		Manufactured	No		1	110	Each	35.0000	1	5			<del></del>
Step											12/0	7./0.1	<u> </u>
				8961 8961	34	Loc Oty 35 10 10	<u>Lo</u>	c Code		3		·	•
<b>D3067-1</b> End Plate		Manufactured	No	8968	35	110	Each	56.0000	1	5	A 12.	10 - [	/
D3219-1 Plate		Manufactured	No	WA 399 7866 8383 8692 8783 WA016 6758 6822 7960	55 23 32 32 32	Loc Otv  52 4 1 45 2 4 2 1 110	<u>Lo</u>	c Code 170.0000	2	5	Mis	?·/ <b>0</b> `//	,
				Location WA 8385 8888 WA016 7341 776	0	Loc Oty  152 92 60 18 12	<u>Lo</u>	<u>c Code</u>		<i>O</i>			

												DQA:	Date	≥:	
NCR:	Yes	/ No				WORK ORDER NON-O	cor	NFORM	MANCE / UP	DATE		•		_	
		•							•			QA Closed:	Date	9:	
Work Orde	or.					DISPOSITION				AGAINST (	DΕ	PARTMENT	PROCESS		4
Part i	۷o.					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite			Water Jet d. Eng. Coor. e/Packaging Supplier		Engineering Quality Other
Root					Descri	ption of work order update		Initial	Ac	tion		Sign &			
Cause		Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Desc	ription		Date	Verification	$ \bot $	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved						•		Ŋ							
						• • • • •	AUI	T CATE	GORY						
Landi	<u> </u>	l			<del></del>	General	_	1		г		1	r	_	L .
		Bending Centre No Cracks Crushed/0		ntric to	o/s	Bend BOM/Route Broken/Damaged Burrs		1	re on Incomplete ions Incomplete/	'Unclear		Ovalized Over/Under Part Incorred Part Lost/Mi	et		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
1	-	Cuffs	•			Contamination		Mainte	-	ļ		Part Moved	٠ ـ ـ ـ		

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

September-24-12 2:55:12 PM

Work Order ID:	90749										
Parent Item:	D350-591-311	•						Start D	Date: 9/24/12		Required Date: 10/26/12
Parent Item Name:	Heli-Access-Step, L	ong LH						Start (	<b>Qty:</b> 5.00		Required Qty: 5.00
D3066-1		Manufactured	No			180	Each	75.0000	2	10	20-24
Spacer										·	B90211 (x 10)
				Location		Loc Oty		Loc Code			te 12.10.17
				WA		75					
				854		15					
				893	99	60					
MS20600-AD4W4		Purchased	No			180	Each	2,746.0000	16	80	Ae 12.10:17
Rivets									G		The 12.10:17
				Location		Loc Qty		Loc Code			
				321		18					
				121	652	18					
				ST311		1000					
				123	021	1000					
				ST321		1728					
					011 .	9					
				121		39				<del>\</del>	
				121	444_	1680			(80		
D3065-041		Manufactured	No			180	Each	11.0000	1	5	BCCC22 (5)
Step Leg Assembly Hi									<del></del>	· · · · - · -	080820
				<b>Location</b>		Loc Qty		Loc Code			Le 12.10.1
r				ST		-20					1 4 1
				850	83	10					
				WA		1					
4 - 4				661		0					
				793	36	1					
				WA013		30					9 12

												DQA:	Date	e: _	•
NCR:	Yes	/ No				WORK ORDER NON-C	01	VFOR	MANCE / UPI	DATE					<b>6</b> , '
			_									QA Closed:	Date	e:_	
Work Ord	er.					DISPOSITION				AGAINST [	ÞΕ	PARTMENT,	PROCESS		•
Part NCR	No.					Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite		1	Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root					Descri	ption of work order update		Initial	Act	ion		Sign &			
Cause		Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Descr	ription		Date	Verification	┙	QC Inspector
Doc/Data Equip/Tooling	-														
Operator	Г			i			1								
Material		]		<u> </u>			1							١	
Setup															
Other		]													
Process									;						
Supplier	L				į										
Training			•	:											
Unapproved	L		<u> 1</u>												
							AUL	T CATE	GORY						·
Land	ing (	7			_	General	_	3		г		7	_	_	I
	<u></u>	Bending				Bend	_	Grain		<u> </u>		Ovalized		-	Pressure/Forced
	<u>_</u>	Centre No	ot Concer	ntric to	O/S	BOM/Route		Hardwa		1		Over/Under	- H	$\overline{}$	Temperature/Cure
	<u> </u>	Cracks			<u></u>	Broken/Damaged	L	4	on Incomplete	Į.		Part Incorre	-	_	Weld
	<u>_</u>	Crushed/	Crimped.		<u> </u>	Burrs		1	ions Incomplete/l	Jnclear		Part Lost/M	ssing		Wrong Stock Pulled
		Cuffs			<u> </u>	Contamination	<u></u>	Mainte		Ļ		Part Moved			
j		Heat Trea	it			Countersink	1	Mislabe	eled			Positioned V	Vrong		

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Other

Power Loss/Surge

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

. , September-24-12 2:55:12 PM

Work Order ID:	90749											
arent Item:	D350-591-311								Star	rt Date: 9/24/12		Required Date: 10/26/12
Parent Item Name:	Heli-Access-Step, I	Long LH							Sta	rt Qty: 5.00		Required Qty: 5.00
<b>D3067-1</b> End Plate		Manufactured	No			180		Each	56.0000	1	5	1212.10.17
				Location		Loc	<u>Otv</u>		Loc Code			
				WA	B90177		52			_5_		
					78608		4					
					83855		1					
					86923		45			-		
					87832		2					,
				WA016			4					
					67582		2					
					68214		1			· · · · · · · · · · · · · · · · · · ·		_
NB-ESA			3.7.		79607	250	l .	- 1	04.0000			
olt		Purchased	No			250		Each	94.0000	8.2.2	10	123352
				Location	<u>1</u>	Loc	<u>Otv</u>		Loc Code			
				FG			10					S
					122800		10					
				ST353			84					•
					122800		84					• 1
3235:1) ounting Lug		Manufactured	No			250	I	Each	56.0000	2	10	90002
				Location	<u>1</u>	Loc	Qty		Loc Code			
				ST471	_		50					
				~-···	88262		50					<b>&lt;</b>
				ST481			6					
				O. 101	83853		6			<del>-</del>		
32573±021]		Manufactured	No			250		Each	63.0000	0.	 5	Carley
pport Assembly												87719 14/y
				Location	<u>1</u>	Loc	<u>Oty</u>		Loc Code			, //
				ST470			40			_		
					89106		40					5
				ST481			23					
					83858		23					

											DQA:	Date:	•
NCR:	res /	No				WORK ORDER NON-	COI	NFORN	MANCE / UPDATE		·		
											QA Closed:	Date:	
Work Orde	or:					DISPOSITION			AGAIN	ST DE	PARTMENT,	PROCESS	•
Work Orde	=1					Rework	٦ ,		Skid-tube Crosstul	oe 🗀	]	Water Jet	Engineering
Part N	No.				•	Scrap	1	ł .	Machining Small F		Pro	d. Eng. Coor.	Quality
	-					Use-as-is		Therm	oforming Finishi	ng	Rec/Stor	e/Packaging	Other
NCR N	No					Work Order Update	_		Large Fab Composi	te	]	Supplier	
Root					Descri	otion of work order update		Initial	Action		Sign &		
Cause		Date	Step	Qty	C	or Non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator													
Material	Ш												
Setup													
Other	Ш										,		
Process													
Supplier	Щ.												
Training	Ш												
Unapproved											<u> </u>		1
						F	AUI	LT CATE	GORY				
Landi	ng Gea				<del></del>	General	_	7		_	7	<del></del> -	7
	⊢	nding				Bend	$\perp$	Grain		<u> </u>	Ovalized	<u> </u> _	Pressure/Forced
	$\vdash$		t Concer	ntric to O	/s	BOM/Route	L	Hardwa		<u> </u>	Over/Under	<del> </del>	Temperature/Cure
	⊢⊣	acks				Broken/Damaged	<u> </u>	-i '	on Incomplete		Part Incorre	h	Weld
	<del></del>		Crimped.		<u> </u>	Burrs	$\vdash$	-1	ions Incomplete/Unclear	<u> </u>	Part Lost/M	issing	Wrong Stock Pulled
		ıffs			<u> </u>	Contamination	<u>_</u>	Mainte			Part Moved		
	—	eat Trea				Countersink		Mislabe		<u> </u> _	Positioned \	· ·	<del>-</del> 1
	∐ln:	spection	Strip in	Tube		Cut Too Short		Misread		L	Power Loss/	Surge	Other
	Ri	pples in	Bend			Drill Holes	1	Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

. . September-24-12 2:55:12 PM

Work Order ID: Parent Item:	90749 D350-591-311			•			Stor	t Date: 9/24/12	Required Date: 10/26/12
Parent Item Name:	Heli-Access-Step, L	ong LH		•				rt Qty: 5.00	Required Qty: 5.00
AN960JD416 Washer	NAS1149D0463J	Purchased	No		250	Each	29.0000		80 M122462 CC
				Location	Loc Oty		Loc Code		<u>~</u>
<i>'</i>				ST351	29				୍ର -
				116289	8				
e .				119097	21			<b>.</b>	_
AN960JD516 Washer	NAS1149D0563J	Purchased	No	•	250	Each	2.0000	4	20 m/21258
				<b>Location</b>	Loc Oty		Loc Code		
				ST338	2				
				1069059	2				- 8
ANS-8641 Bolt		Purchased	No	100,000	250	Each	176.0000	2	10 -
				Location	Loc Qty		Loc Code		
				ST338	50				
				123021	50			12302	7
				ST340	26				
				122141	26				<del>-</del>
				ST358	100				_
				122808	100			er.	-
D2618 Bushing		Manufactured	No		250	Each	99.0000	2	10 -90/04
				Location	Loc Qty		Loc Code		,
				ST013	99				
				76130	2				·
				84646	3				
				85446	10				<del>-</del>
				86844	84				

											DQA:	Date:	4
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UPD	DATE		_	•
						***********					QA Closed:	Date:	
Work Ord	or.					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	•
Work Ord	CI.					Rework	٦		Skid-tube	Crosstube		Water Jet	Engineering
Part	No.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					<del></del>	Use-as-is	1	Therm	noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR	No.				<u> </u>	Work Order Update	]		Large Fab	Composite		Supplier	
Post					Dossri	ption of work order update		Initial	Acti	ion	Sign &		1
Root Cause		Date	Step	Qty		or Non-conformance	1	ifiitiai iief Eng	Descri		Date	Verification	QC Inspector
Doc/Data	1	Date	step	Qty		or Non-comormance	101	Her Eng	Descri	iption	Date	vermeation	QC IIISPECTOI
Equip/Tooling	_												
Operator	$\vdash$	}											
Material	$\vdash$					•							
Setup	一						İ						
Other	$\vdash$												
Process	$\vdash$												}
Supplier	Г												
Training	Г	1			: !							•	
Unapproved													
						F	AUL	T CATE	GORY				
Landi	ing (	Gear				General		-			-		-
	L	Bending				Bend		Grain			Ovalized		Pressure/Forced
	oxdot	Centre No	ot Concer	ntric to (	O/S	BOM/Route	L	Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
		Crushed/	Crimped.			Burrs	_	-	ions Incomplete/U	Jnclear	Part Lost/M	issing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	enance		Part Moved		
		Heat Trea	it		L	Countersink		Mislabe	eled		Positioned V	Vrong	<b>_</b>
}	Inspection Strip in Tube			Cut Too Short		Misread			Power Loss/	Surge	Other		

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

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Loc Code Loc Qty 316 719 122452 719 ST300 546 117885 32 119017 376 119075 138 ST317 1228 122141 1228

September-24-12 2:55:13 PM

Shop Packet Print

Page 5

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-	COI	<b>VFOR</b>	MANCE / UP	DATE			, •
											QA Closed:	Date:	
Work Ord	or.					DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS	•
WORK OIG	CI.					Rework	7		Skid-tube	Crosstube	]	Water Jet	Engineering
Part !	No.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is	]	Therm	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR I	No.					Work Order Update	]		Large Fab	Composite	]	Supplier	
Root			<u> </u>	<u> </u>	Descri	ption of work order update	T	Initial	Ac	tion	Sign &		
Cause		Date	Step	Qty	1	or Non-conformance	1	nief Eng		ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator					]								
Material						•							
Setup	L												
Other	L												
Process			1						:				
Supplier			:				1						
Training													
Unapproved			<u> </u>										
<u></u>						F	AUL	T CATE	GORY	·			
Landi	ng (	Gear				General		-			_		-
	<u>_</u>	Bending				Bend		Grain		<u> </u>	Ovalized		Pressure/Forced
		Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks			<u> </u>	Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
Crushed/Crimped			Burrs Instructions Income			ions Incomplete/	'Unclear	Part Lost/M	issing	Wrong Stock Pulled			

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Part Moved

Positioned Wrong

Power Loss/Surge

Other

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

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. September-24-12 2:55:13 PM

Work Order ID: 90749 Parent Item: **Start Date: 9/24/12** D350-591-311 Required Date: 10/26/12 Parent Item Name: Heli-Access-Step, Long LH Start Qty: 5.00 Required Qty: 5.00 No 250 Each 1,694.0000 Purchased Bolt Location Loc Oty Loc Code FG 20 122808 20 ST356 1481 118838 8 122416 498 122808 475 122993 500 ST357 193 120187 19 120770 12 161 121652 [ w/s/22 6 122063 MS210421\61 No 250 Each 1,469.0000 Purchased Loc Code Location Loc Qty 300 363 121652 363 121652 314 1000 122452 1000 ST300 106 108827 4 116105 116548 43 46 119109 2937 12

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-O	CON	IFOR	MANCE / UPI	DATE		<u> </u>	
								·			QA Closed:	Date:	
Work Ord	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	,
Part No					<del></del>	Scrap Machining Small Fab Use-as-is Thermoforming Finishing		Crosstube Small Fab Finishing Composite	-	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other		
						<u> </u>			·				·
Root					Descri	ption of work order update	11	nitial	Act	ion	Sign &		
Cause		Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling	_			•					:				
Operator	<u> </u>			:									
Material	ļ												
Setup	<u> </u>												
Other	_												
Process	⊢												
Supplier	<u> </u>					*					1		
Training	⊢												
Unapproved	<u> </u>	<u> </u>	<u> </u>	<u> </u>		<u>-</u>	1				1		
							AUL	T CATE	GORY				
Landi	ng (	7				General					<b>a</b>	<b>_</b>	1 .
	<b>—</b>	Bending			.	Bend	$\vdash$	Grain		<u> </u>	Ovalized		Pressure/Forced
1	L.	Centre No	ot Concer	ntric to	o/s	BOM/Route	$\vdash$	Hardwa			Over/Under		Temperature/Cure
1	1	Cracks			1	Broken/Damaged	1 1	Inspect	ion Incomplete		Part Incorre	ect	Weld

Instructions Incomplete/Unclear

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Part Moved

Wrong Stock Pulled

Other

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Crushed/Crimped.

Inspection Strip in Tube

Torque Waves in Extrusion

Cuffs

Heat Treat

Burrs

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

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. September-24-12 2:55:13 PM

Work Order ID: Parent Item: Parent Item Name: MS2104214 Nut

90749

D350-591-311

NAS1149D0363J

Heli-Access-Step, Long LH

Purchased

No

**Start Date: 9/24/12** 

Required Date: 10/26/12

Start Qty: 5.00

Required Qty: 5.00

<b>Location</b>	Loc Qty	Loc Code		·
314	3085			
122452	3085			
FP001	3			_ ^
8182	3			Smi
ST300	27			
119017	20			
121444	7			
ST314	3000			
123021	3000			
	250	Each 0.0000	20	m12346 R

6,115.0000



Purchased No

250

Each

Date:
OCESS '
Vater Jet Engineering ng. Coor. Quality ackaging Other Supplier
erification QC Inspector
Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
g ng

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

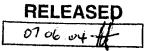
Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



	DESIG	N <sub>C</sub>	DRAWN BY	DART AEROSPACE L	TD.
		41	平	HAWKESBURY, ONTARIO, CANADA	'
	CHEC	SED	APPROVED	DRAWING NO.	REV. B
	_ <	E		D3272 si	HEET 1 OF 3
	DATE			TITLE	SCALE
_	07.0	05.18		STEP ASSEMBLY, HI LONG	NTS
	Α		04.03.01	NEW ISSUE	
	В		07.05.18	D3272-1 WAS D2622-120	

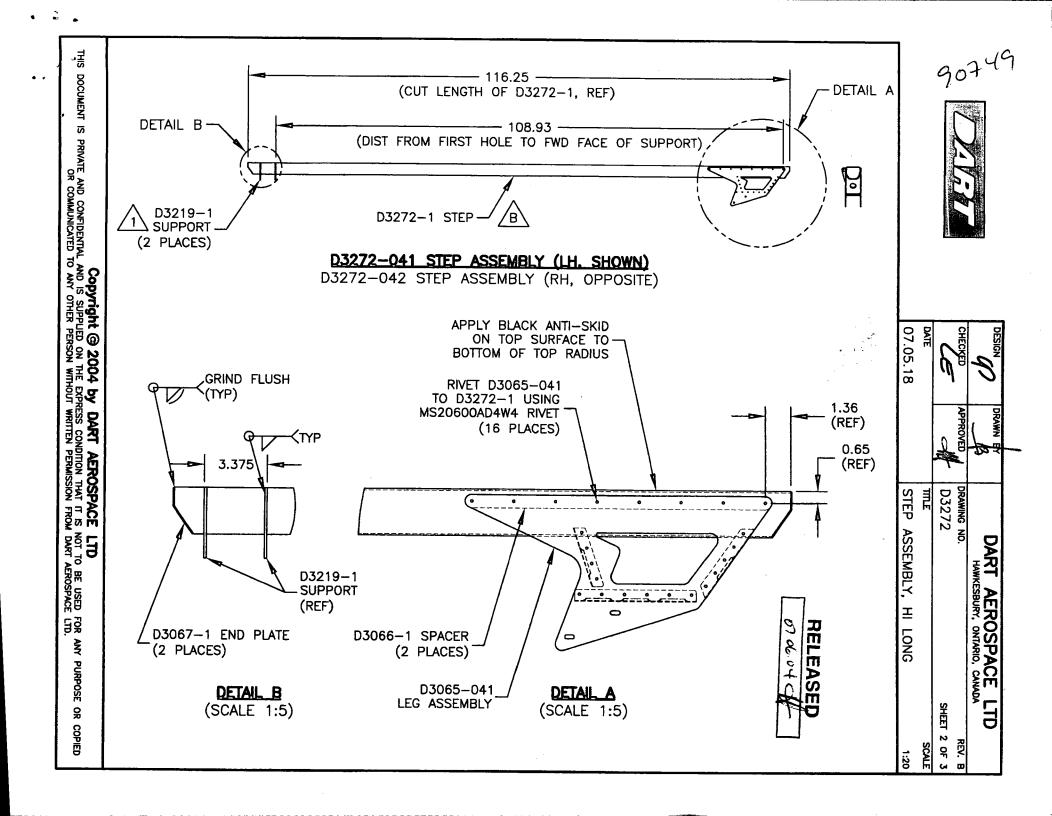


QTY		
-042	PART NUMBER	DESCRIPTION
	D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
Х	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	D3065-041	LEG ASSEMBLY
2	D3066-1	SPACER
2	D3067-1	END PLATE
2	D3219-1	SUPPORT
11	D3272-1	STEP
16	MS20600AD4W4	RIVET
	-042 X 1 2 2 2	-042 PART NUMBER  D3272-041  X D3272-042  1 D3065-041 2 D3066-1 2 D3067-1 2 D3219-1 1 D3272-1

## **GENERAL NOTES:**

- D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1 POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

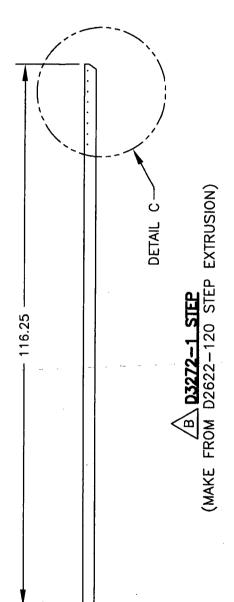
NCONTROLLUD COPY INECT TO AMENDMENT ENGINEERING

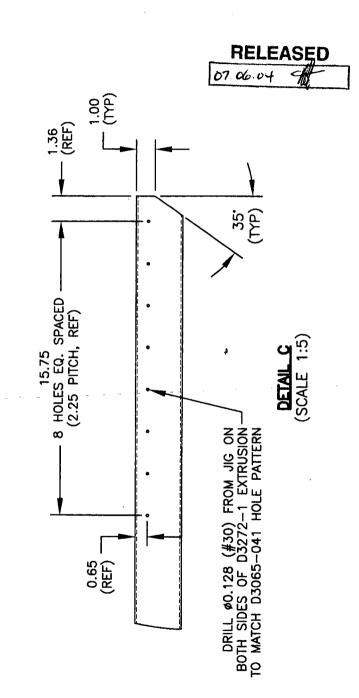


bhtob



DESIGN	DRAWN BY	DART AEROSPACI HAWKESBURY, ONTARIO, CA	
CHECKED	APPROVED /	DRAWING NO.	REV. B
LE		D3272	SHEET 3 OF 3
DATE		TITLE	SCALE
07.05.18		STEP ASSEMBLY, HI LONG	1:20





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## REFERENCE ONLY

## DART AEROSPACE LTD.

D350-591 Page 23 of 23

Qty	Qty	Qty -213	Qty	Qty -215	Qty -216		Qty ) 311	Qty -312	Part Number	Description
-211 X	-212	-213	-214	-215	-210	1 - 1	11	-312	D350-591-211	Heli-Access-Step™, Long Step – High Skid, LH
_^_						+	+		D350-591-212	Heli-Access-Step™, Long Step – High Skid, RH
	X					+			D350-591-213	Heli-Access-Step™, Short Step - High Skid, LH
		X				┼┼	1		D350-591-213	Heli-Access-Step ™, Short Step - High Skid, RH
			X	X		+			D350-591-214	Heli-Access-Step M, Short Step - High Skid, KH
					Х	+-{	+		D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
						+ !	J			
						+	X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
						1		Х	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1						+ 1	+		D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1					+ :	+ -		D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
<b>├</b>		1				+ {	+		D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
<b>├</b> ──┼			1			+{	-		D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
<u> </u>				1		╅╌╏	+		D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
<b> </b>				<u> </u>	1	╅╉	+		D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						+-{	11		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
<b>├</b> ──┤						+	+	1	D3272-041	STEP ASSEMBLY (HIGH-LONG, RH)
<del>├</del> ─┼	4					+-;	+	<u>'</u>	D2182B035	RUBBER CUSHION
4	4	2	2	2	2	+-:	+		D2182B033	MOUNTING LUG
<b> </b>		2	2	2	2	+-+	4	4	D2230=3	EMOUNTING-LUG-
<b>├</b> ~~	8					+ {	1		D2274	RADIUS BLOCK
8	- 0					++	21	2	-D2618>	-BUSHING
┝┈┼		<del></del>	4	4	4	+-;	4	٠,	D2732-030	CUSHION
4	2	1	1	1	1	+-	2	2	4D2856#409=720.)	ABRASION:STRIP
2	2	<u> </u>				╁╌	- 1		D3064-1	CLAMP
2						+-	-		D3079-041	SUPPORT ASSEMBLY
1	1					┽┈	-}-		D3080-1	GLAMP-
4	4					+	2	2	4D3235=17	MOUNTING THE-
		-					11	1	D3278:041=>	SUPPORT ASSEMBLY
						+	<del>!' ! -</del>		25.027.0±0H-1=	SOLITOIS, AGOEMBELL
2	2	2	2	2	2	$\top$	2	2	AN3:35A	BOLT
10	10	2	2	2	2	$\top$			AN4-11A	BOLT
<del> '`- </del>	<u> </u>	4	4	4	4	$\top$	8 1	8	-AN4-13A-	_BOLT=
$\vdash$		<u> </u>	· · · · · ·	<u> </u>	<del>                                     </del>	$\top$	2 1	2	-AN5-36A-5	CBOL1-2
4	4	4	4	4	4	+	4 1	4	AN960JD40> -	
20	20	12	12	12	12	$\top$	16	16	AN960JD416	AWASHER*
		<del>  '-</del>	<del></del>	<u> </u>	├ <i>╌</i>	1	4			=WASHER=
2	2	2	2	2	2	+	2	2	MS21042L3	- FUND
10	10	6	6	6	6	+	8	8		4NUTO
<del>  ''  </del>	10	<del> </del>	<del>├─ॅ</del> ─	<del>_ </del>	<u> </u>	+-	2 1			G-NB∓>
<b> </b>			<del> </del>			+	11	1	*DSI 9410-011	STEP MODIFICATION KIT

\*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

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Revision:  ${\bf G}$ Date: 08.10.06